

Date: Tuesday, 11/6/2007 3:42:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 35589	
Estimate Number : 12337	
P.O. Number : <i>N/A</i>	Part Number : D3492043
This Issue : 11/6/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3492 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 33076	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/23/2007 Qty: 80 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A 06.03.21 New Issue JLM	
Est Rev: B 06-08-28 As per Rev B JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 5.2500 f(s)
 6061-T6 Round Bar .750"

(M6061T6R750)

Batch: *194730**4.4'**20 07/11/09*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA632 & Dwg D3492

Dwg Rev: *13*Folio Rev: *13**20 07/11/09*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*20 07/11/09**(80)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

20 07/11/09

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

*SAD 07-11-17**(80)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 27/11/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 35589

Part Number: D3492043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 07/11/19 (80)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Flat End Only)

BL 07-11-20 (80)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. 07/11/20 (80X)

9.0

NAS1611013

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-013 O-RING

M 103154 (19X)
M 105516 (61X)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

2-Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch: _____

M 101223 M. 07/11/20

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M 07/11/20 (80)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

FP 7 M. 07/11/20 (80X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/11/20

Job Completion



u 07.11.21

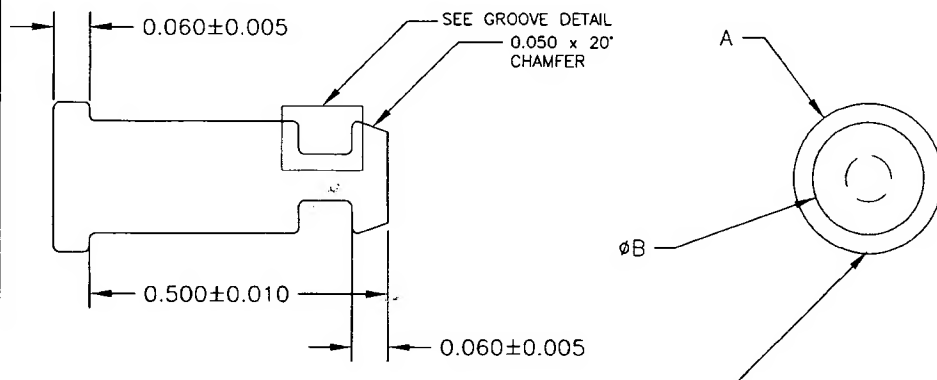
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

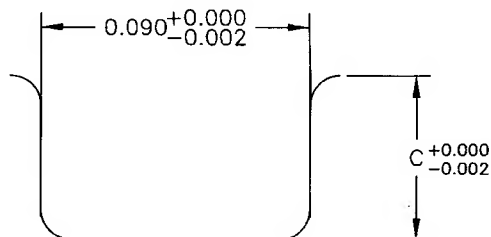
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-1/-3/-5/-7 PLUGS IN ACCORDANCE WITH TABLE 1



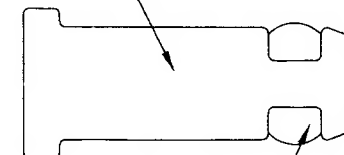
GROOVE DETAIL

TABLE 1 D3492-1/-3/-5/-7 PLUG DIMENSIONS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500



D3492-1/-3/-5/-7 PLUG IN ACCORDANCE WITH TABLE 2



NAS1611-005/-007/-010/-013 O-RING IN ACCORDANCE WITH TABLE 2

D3492-041/-043/-045 PLUG ASSEMBLY

RELEASED
06.10.04 PH
P/N: ELN #351

D3492-041/-043/-045 PLUG ASSEMBLY PARTS LIST
(TABLE 2)

Qty -041	Qty -043	Qty -045	Qty -047	Part Number	Description
X				D3492-041	PLUG ASSEMBLY
	X			D3492-043	PLUG ASSEMBLY
		X		D3492-045	PLUG ASSEMBLY
			X	D3492-047	PLUG ASSEMBLY
1				D3492-1	PLUG
	1			D3492-3	PLUG
		1		D3492-5	PLUG
			1	D3492-7	PLUG
		1		NAS1611-005	O-RING
			1	NAS1611-007	O-RING
1				NAS1611-010	O-RING
	1			NAS1611-013	O-RING



D3492-1/-3/-5/-7 PLUG NOTES

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6RD.DDD)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTE
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

NO. 35589
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
 SUBJECT TO A/E/EN/ENT
 RETURN TO
 ENGINEERING
 SHOP COPY

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B	06.05.11	ADD -047; UPDATE DIM A,-045
A	06.01.04	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	APPROVED	DRAWING NO. D3492
DATE	06.05.11	TITLE PLUG
		REV. B SHEET 1 OF 1 SCALE NTS